

Work Order ID 66319

February 9, 2011 3:42:47 PM



Page 1

Item ID: D206-628-024

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step RH

Start Date: 2/11/11 Start Qty: 3.00



Cust Item ID:

Required Date: 2/24/11 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: *MF*

Date: *11-02-10* Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
N/A	Rev N/A								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels as per PPP D206-628-024 CHG 003

S-1

11/03/14

HJ for BG 11-9-3

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/3/10 *SL(32)*

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8x603114

73
RM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 2/24/11 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-628-024 Location: <u>71</u> PPP Rev: <u>5</u>								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/3/14 *[Signature]*(32) *[Signature]*11/3/15 *[Signature]*

ME

11-03-15

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 66319

Parent Item: D206-628-024

Parent Item Name: Heli-Access-Step RH



Start Date: 2/11/11

Required Date: 2/24/11

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM
 IPP Rev:E as per ecn 1118 08-02-05 DD verified by:EC
 IPP rev F ncr 09-004 09.01.09 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3C4A BOLT		Purchased	No			120	Each	1,600.000	3	9		11/3/10	
----------------	--	-----------	----	--	--	-----	------	-----------	---	---	--	---------	--

Location	Loc Qty	Loc Code
ST350	1600	
115300	25	
116075	491	
116590	84	
116704	1000	

AN4C14A Bolt		Purchased	No			120	Each	57.0000	4	12		11/3/10	
-----------------	--	-----------	----	--	--	-----	------	---------	---	----	--	---------	--

Location	Loc Qty	Loc Code
ST358	57	
115835	7	
115936	50	

AN4C15A Bolt		Purchased	No			120	Each	93.0000	8	24		11/3/10	
-----------------	--	-----------	----	--	--	-----	------	---------	---	----	--	---------	--

Location	Loc Qty	Loc Code
ST358	93	
115936	93	

AN960C10 WASHER	NAS1149C0363 R	Purchased	No			120	Each	0.0000	3	9		11/3/10	
--------------------	-------------------	-----------	----	--	--	-----	------	--------	---	---	--	---------	--

W/O:		WORK ORDER CHANGES					
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Work Order ID: 66319

Parent Item: D206-628-024

Parent Item Name: Heli-Access-Step RH

Start Date: 2/11/11

Required Date: 2/24/11

Start Qty: 3.00

Required Qty: 3.00

AN960C416L

Purchased No

120

Each

19.0000

24 72

WASHER

Location

Loc Qty

Loc Code

ST346

19

112828

19

Manufactured No

120

Each

68.0000

4 12

D2731-7

Mounting Lug

Location

Loc Qty

Loc Code

ST420

2

65224

2

ST470

66

61653

1

62402

15

62929

50

Manufactured No

120

f

529.9793

2

D2732

Rubber Extrusion

Location

Loc Qty

Loc Code

ST410

500

64283

500

ST412

29.979279

56516

29.979279

Manufactured No

120

Each

0.0000

3

(D2732-030) Cut (8) at 3.00"

D2842-042

Step Assembly RH, 206 Float

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D206-628-024

Parent Item Name: Heli-Access-Step RH

Start Date: 2/11/11

Required Date: 2/24/11

Start Qty: 3.00

Required Qty: 3.00

S
D2844-1
Arm

Manufactured No

120 Each

17.0000

11/3/10 SP B6CS61

Location

Loc Qty

Loc Code

ST265

17

52030

1

62954

16

S
D2844-3
Arm

Manufactured No

120 Each

13.0000

11/3/10 SP

Location

Loc Qty

Loc Code

ST265

13

61453

1

62967

12

S73
D3394-043
Lug Assembly

Manufactured No

120 Each

87.0000

11/3/10 SP B2

Location

Loc Qty

Loc Code

ST420

3

62589

3

ST475

84

62005

6

62667

8

62930

40

62976

30

2
10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 66319

Parent Item: D206-628-024

Parent Item Name: Heli-Access-Step RH

Start Date: 2/11/11

Required Date: 2/24/11

Start Qty: 3.00

Required Qty: 3.00

MS21043-4

Purchased

No

120

Each

1,029.000

12 36

Nut

Location

Loc Qty

Loc Code

ST301

1029

114523

5

114784

2

115936

126

116188

596

116549

300

NAS1515H3

Purchased

No

120

Each

150.0000

3 9

Washer

Location

Loc Qty

Loc Code

ST277

150

115935

50

116373

100

NAS1515H4L

Purchased

No

120

Each

106.0000

24 72

WASHER

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

66

112492

11

114265

55

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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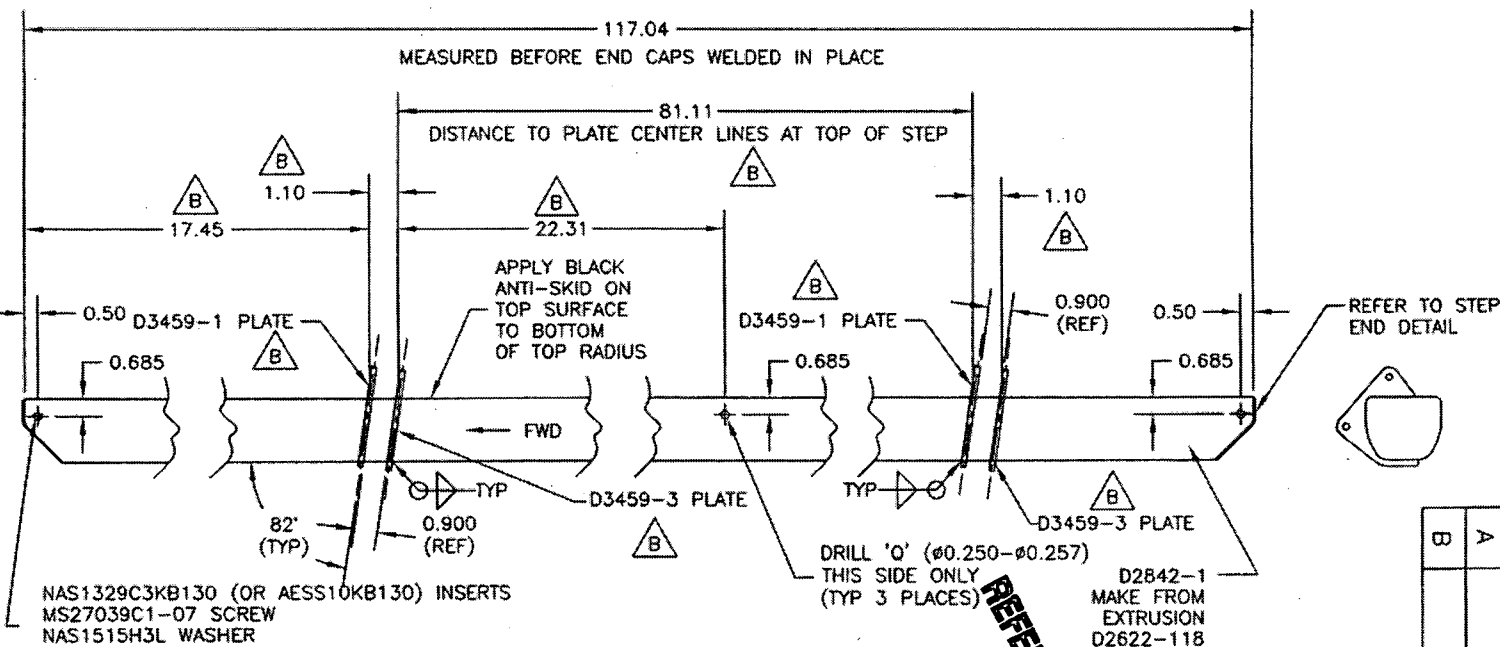
5.2 D206-628-013/-014/-023/-024/-033/-033 FLOAT COMPATIBLE DART HELI-ACCESS-STEPS™ PARTS LIST

Qty -013	Qty -014	Qty -023	Qty -024	Qty -033	Qty -034	Part Number	Description
X						D206-628-013	206 A/B FLOAT STEP INST. LH
	X					D206-628-014	206 A/B FLOAT STEP INST. RH
		X				D206-628-023	206 L/L1/L3/L4 FLOAT STEP INST. LH
			X			D206-628-024	206 L/L1/L3/L4 FLOAT STEP INST. RH
				X		D206-628-033	407 FLOAT STEP INST. LH
					X	D206-628-034	407 FLOAT STEP INST. RH
2	2			4	4	D2731-3	MOUNTING LUG
2	2	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
1						D2841-041	FLOAT STEP ASSEMBLY LH
	1					D2841-042	FLOAT STEP ASSEMBLY RH
		1		1		D2842-041	FLOAT STEP ASSEMBLY LH
			1		1	D2842-042	FLOAT STEP ASSEMBLY RH
		2	2	2	2	D2844-1	ARM
		1	1	1	1	D2844-3	ARM
2	2					D2845	ARM
2	2			4	4	D3394-041	MOUNTING LUG
2	2			4	4	*D3394-1	*MOUNTING LUG
4	4			8	8	*MS35489-93	*GROMMET
2	2	4	4			D3394-043	MOUNTING LUG
2	2	4	4			*D3394-3	*MOUNTING LUG
4	4	8	8			*MS35489-93	*GROMMET
2	2	3	3	3	3	AN3C4A	BOLT
4	4					AN4C13A	BOLT
4	4	4	4	8	8	AN4C14A	BOLT
4	4	8	8	4	4	AN4C15A	BOLT
2	2	3	3	3	3	AN960C10	WASHER
24	24	24	24	24	24	AN960C416L	WASHER
24	24	24	24	24	24	NAS1515H4L	WASHER
12	12	12	12	12	12	MS21043-4	NUT
2	2	3	3	3	3	NAS1515H3	WASHER

*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
KE	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
05.09.23	05.09.23	D2842
DATE	TITLE	206L/407 FLOAT STEP ASSEMBLY
		NEW ISSUE
		RE-DESIGN, ADD D3459-1/-3
		SCALE
		REV. B
		SHEET 1 OF 1

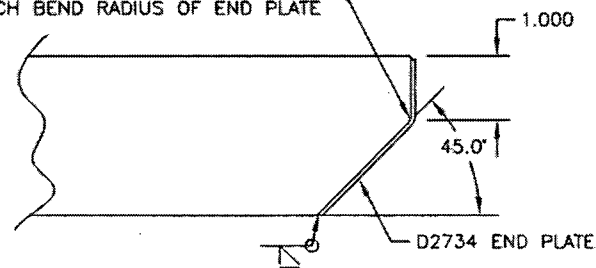


D2842-041 LH STEP ASSEMBLY (SHOWN)
D2842-042 RH STEP ASSEMBLY (OPPOSITE)

D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X	X	D2842-041	LH STEP ASSEMBLY
		D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05.11.14